

Work Order ID 65551

January 19, 2011 1:39:32 PM



Page 1

Item ID:	D3065-3	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Step Spacer					
Start Date:	1/20/11	Start Qty:	40.00		Cust Item ID:	
Required Date:	1/28/11	Req'd Qty:	40.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>mf</u>	Date:	<u>11-01-19</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3065	Rev B								

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	I-Cut as per Dwg D if necessary		<input checked="" type="checkbox"/> Dwg Rev: <u>B</u>	<input type="checkbox"/> Prog Rev: <u>B</u>	<input type="checkbox"/> 2-Deburr				
2674.040									(40)

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

0

Sublot 26

Counted
(40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. The second step is to define the objectives and goals of the project. This involves determining what you want to achieve and how you will measure success.

3. The third step is to develop a plan of action. This involves identifying the steps that need to be taken to achieve the objectives and goals.

4. The fourth step is to implement the plan. This involves putting the plan into action and monitoring progress.

5. The fifth step is to evaluate the results. This involves assessing the outcomes of the project and determining whether the objectives and goals have been achieved.

6. The sixth step is to report on the results. This involves communicating the findings of the project to the relevant stakeholders.

7. The seventh step is to review the process. This involves reflecting on the project and identifying areas for improvement.

8. The eighth step is to document the results. This involves creating a record of the project and its outcomes.

9. The ninth step is to share the results. This involves disseminating the findings of the project to a wider audience.

10. The tenth step is to conclude the project. This involves finalizing all tasks and ensuring that everything is in order.

Page 2

Accept

[illegible]**Setup Start**

Stop

**Cust Item ID:**[illegible]

Customer:

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

**Insp.
Stamp**

0.00

[REDACTED]

Small Fab

0.00

Small Fab

Memo

Small Fab

Deburr Stack

N/A

0.00

[illegible]

NC BRAKE

0.00

Brake NC

Memo

Brake NC

Bend as per Dwg D3065

SB 11/02/01

40

0.00

[illegible]

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

Quality Control

00 8410261

center
740

W/O:		WORK ORDER CHANGES					
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Work Order ID 65551

January 19, 2011 1:39:33 PM



Page 3

Item ID: D3065-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Spacer

Start Date: 1/20/11 Start Qty: 40.00



Cust Item ID:

Required Date: 1/28/11 Req'd Qty: 40.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00		11/02/06		40	0		
170 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
180 Packaging Packaging	Identify as per dwg & Stock Location <u>Small FAB</u> Memo	0.00 0.00							

40 BR 11-02-4

11/2/3 400 SP

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 65551

January 19, 2011 1:39:34 PM



Page 4

Item ID: D3065-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Spacer

Start Date: 1/20/11 Start Qty: 40.00



Cust Item ID:

Required Date: 1/28/11 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/07

CL1102104

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

January 19, 2011 1:39:32 PM

Page 1

Work Order ID: 65551

Parent Item: D3065-3

Parent Item Name: Step Spacer



Start Date: 1/20/11

Required Date: 1/28/11

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP: ☐C☐02.11.01☐Incorporated D3066-1 IPP☐KJ/RF
IPP Rev:D Now on Water Jet 06-04-11 JLM☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	216.4595	0.2178	9.170526			
											181-1-25		

2024-T3 .040 sheet

Location	Loc Qty	Loc Code
MAT	28.2	
114415	28.2	
MAT22	188.2595	
110305	21.93	
111786	9.66	
112291	28.25	
112331	52	
113162	76.4195	

114415

40

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DART AEROSPACE LTD		Work Order: 65551
Description: Step Spacer		Part Number: D3065-3
Inspection Dwg: D3065	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.260	+/-0.010	1.259	✓		M13-22 vern	
3.260	+/-0.010	3.260	✓		4	
5.260	+/-0.010	5.263	✓		4	
6.520	+/-0.010	6.518	✓		4	
2.093	+/-0.010	2.091	✓		4	
3.936	+/-0.010	3.933	✓		4	
4.186	+/-0.010	4.190	✓		4	
Ø0.128	+0.005/-0.000	.133	✓		4	
Ø1.250	+0.005/-0.000	1.252	✓		4	
Pitch 1.204	+/-0.005	1.203	✓		4	
0.040	+/-0.010	.040	✓		4	

Measured by: RB	Audited by: [Signature]	Prototype Approval: N/A
Date: 11-1-25	Date: 11/1/26	Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue	KJ/RF	
B	04.08.12	Removed dimension 1.204	KJ/JLM	
C	06.06.23	Dwg Rev. changed	KJ/JLM	
D	07.09.06	0.040 dimension added	KJ/JLM	[Signature]

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

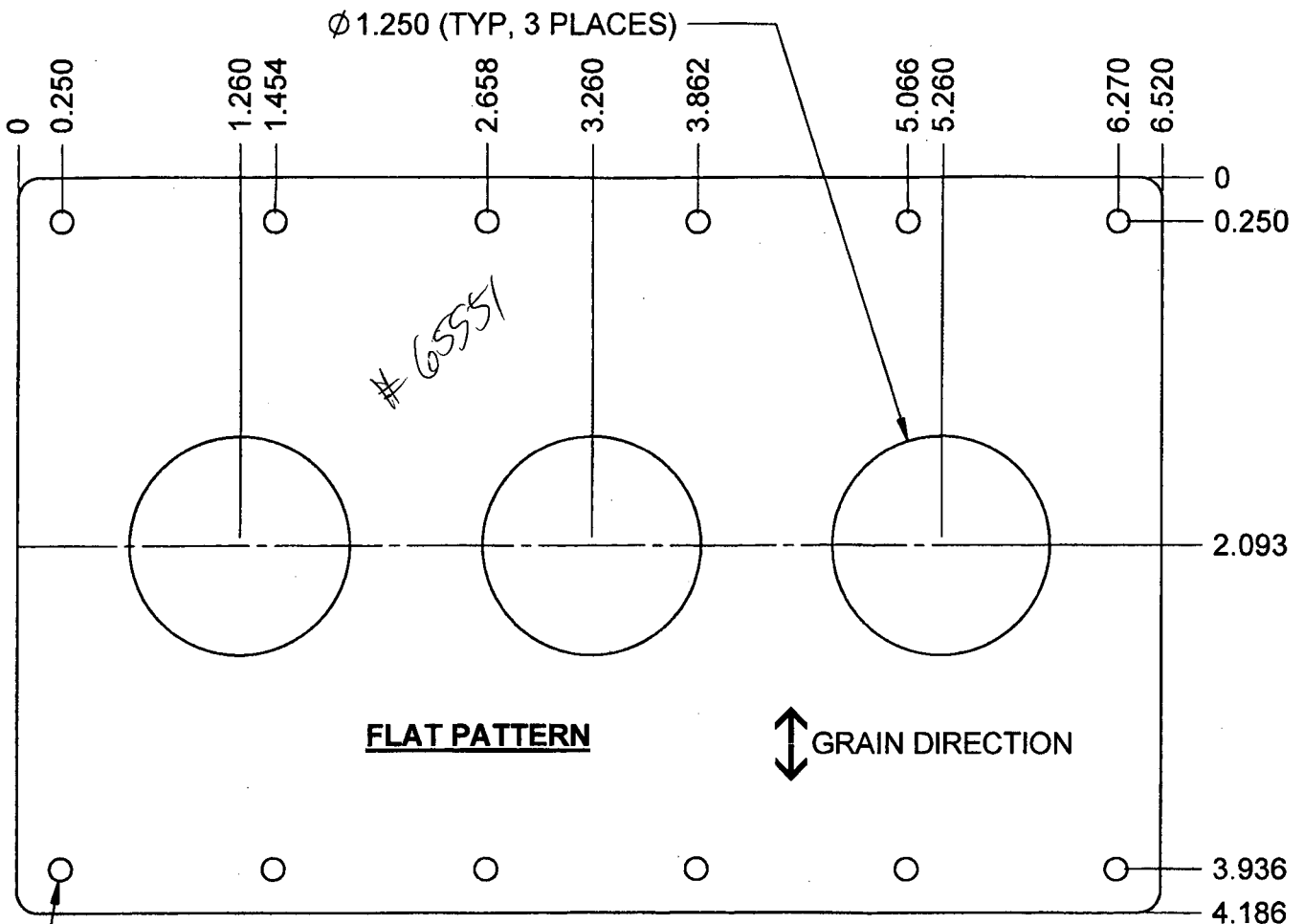
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 3 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

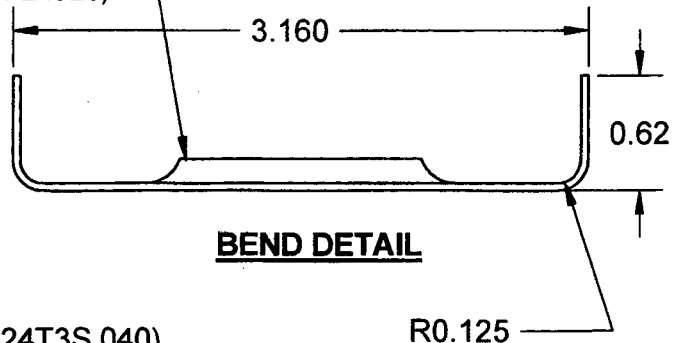


FLANGE AFTER TOWARDS SIDE
SHOWN USING DT8174 (3 PLACES)

Ø 0.129 (TYP, 12 PLACES)

RELEASED

06.06.20 *[Signature]*



BEND DETAIL

D3065-3 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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